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METHOD FOR MANUFACTURING HIGH SILICON GRAIN-ORIENTED
ELECTRICAL STEEL SHEET WITH SUPERIOR CORE LOSS PROPERTY

TECHNICAL FIELD

5 The present invention relates to a method for manufacturing a high silicon grain-oriented electrical steel sheet that can improve magnetic properties, especially, core loss characteristic, and more specifically, to a method for manufacturing a high silicon grain-oriented
10 electrical steel sheet in which powder coating agent containing an annealing separator for siliconization is coated on the surface of a steel sheet, and finished annealed to thereby manufacture an electrical steel sheet with outstanding high frequency magnetic properties as well
15 as outstanding commercial frequency properties.

BACKGROUND ART

Electrical steel sheets are generally classified into grain-oriented electrical steel sheet and non-oriented
20 electrical steel sheet. Grain-oriented electrical steel sheet contains 3% silicon (Si) and has a texture in which grains are oriented in an orientation $\{(110)[001]\}$. Superior magnetic properties in the rolling direction allow these grain-oriented electrical steel sheet products to be
25 used as core material of transformers, motors, generators

and other electronic devices.

Recently, as electrical devices are diversified, demands on devices operating in high frequency band increase and thus desires on core material with superior magnetic properties in high frequency also start to increase.

In the meanwhile, in alloys of Fe-Si, since higher silicon contents allow hysteresis loss, magnetostriction, coercive force, and magnetic anisotropy among core loss properties to decrease and maximum permeability to increase, it is said that high silicon steel products are superior soft magnetic material. Then, the decrease of magnetostriction and the increase of maximum permeability do not continue limitlessly according to increase of silicon content but show maximum values in 6.5% Si steel. Also, it is well known that magnetic properties of 6.5% Si steel reach the maximum state in high frequency band as well as commercial frequency band. Due to the superior magnetic properties in high frequency band, high silicon steel is mainly applicable to high frequency reactor for gas turbine generator, tank power supply, induction heating device, uninterruptible power supply or the like, and high frequency transformer for plating power supply, welding machine, X-ray power supply or the like, and is being used as substitution material of silicon grain-oriented steel.

In addition, the high silicon steel is applicable for use to reduce power consumption of a motor and improve the efficiency of the motor.

Then, since elongation of the silicon steel sheet decreases abruptly as silicon content in Fe-Si steel increases, it is known that it is nearly impossible to manufacture the silicon steel sheet containing in excess of 3.5% Si by a cold rolling. In spite of such a fact that higher Si contents are effective in obtaining superior magnetic properties, the manufacture of such a high silicon steel sheet is recognized as a limitation of the cold rolling. Accordingly, researches on a new substitution technology that can overcome the limitation of the cold rolling are being tried from a long time ago.

As prior arts known as methods that can manufacture high silicon steel sheets, Japanese Patent Laid Open Publication No.S56-3625, etc., discloses a direct casting of a high silicon steel using a single roll or twin rolls, Japanese Patent Laid Open Publication No.S62-103321, etc., discloses a warm rolling in which rolling is performed in a heating state of a proper temperature, and Japanese Patent Laid Open Publication No.H5-171281, etc., discloses a clad rolling in which rolling is performed in a state that high silicon steel is located at an inner portion and low silicon steel is located at an outer portion. However, the

aforementioned prior arts have been not yet commercialized.

For mass production of high silicon steel products such as 3% Si non-oriented steel products, there is well known a process including steps of depositing silicon on a surface of a material by a chemical vapor deposition using SiCl₄ and then homogenizing the silicon in prior arts of Japanese Patent Laid Open Publication No.S62-227078, US Patent No.3,423,253 and the like. However, the above process causes the produced products to be sold inevitably at a price five times higher than the conventional 3% Si steel products due to the difficulty in the CVD process. In spite that the produced products have superior magnetic properties, it is difficult to popularize and commercialize such products.

Among the currently circulated electrical steel products, only non-oriented electrical steel sheets containing 6.5% Si are produced and sold as the high silicon steel product. Owing to an irregular arrangement of grain, the non-oriented electrical steel sheets containing 6.5% Si content is used in the rotator with a small magnetic deviation according to magnetizing directions orientations. However, high silicon grain-oriented electrical steel sheet products, which demonstrate excellent characteristics in use for the transformer mainly using only the magnetic property in the rolling direction,

have been not yet commercialized. Accordingly, various tries for producing a grain-oriented electrical steel sheet with superior magnetic properties due to high silicon content have been performed, but it has not been informed yet of a success to produce such products.

DISCLOSURE OF THE INVENTION

Accordingly, the present invention has been made in an effort to solve the above-described problems of the prior art.

An object of the invention is to provide a method for manufacturing a high silicon grain-oriented electrical steel sheet with more excellent high frequency magnetic characteristics than the conventional steel sheet by coating powder coating agent containing an annealing separator on a surface of a steel in a slurry state, and diffusion annealing the resultant steel so as to produce a high silicon steel sheet.

To achieve the above object and other advantages and in accordance with the purpose of the invention, as embodied and broadly described herein, in a method for manufacturing a high silicon grain-oriented electrical steel sheet, comprising the steps of: reheating and hot-rolling a steel slab to produce a hot-rolled steel sheet; annealing the hot-rolled sheet and cold rolling the

annealed steel sheet so as to adjust a thickness of the steel sheet; decarburization annealing the cold-rolled steel sheet; and finish-annealing the decarburization annealed steel sheet for secondary recrystallization,

5 the improved method being characterized by further comprising the steps of: coating a powder coating agent for siliconization on a surface of the decarburization annealed steel sheet in a slurry state, the powder coating agent including 100 part by weight of MgO powder and 0.5 - 120
10 part by weight of sintered powder of Fe-Si compound containing 25 - 70 wt% Si sintered powder, the sintered powder having a grain size of -325 mesh;

drying the resultant decarburization annealed steel sheet; and

15 finish-annealing the steel sheet under a conventional condition.

BEST MODE FOR CARRYING OUT THE INVENTION

Hereinafter, the present invention will be described.

20 The manufacturing processes of the grain-oriented electrical steel sheet have somewhat differences according to manufacturers. However, each of the processes generally includes the steps of: adjusting the contents of components in steel making process; producing a casting slab;
25 reheating the casting slab; hot rolling the reheated

casting slab; annealing the hot rolled sheet and cold rolling the hot-rolled steel sheet so as to adjust the thickness of the steel sheet; decarburization annealing the cold-rolled steel sheet; high temperature annealing the steel sheet for a secondary recrystallization; and finish coating an insulating film on the steel sheet. The above process is based on mass production. In the mass production, it is an important factor to establish a production facility toward the cold rolling. Then, as aforementioned, higher silicon content in the electrical steel sheet decreases core loss, magnetostriction, coercive force, and magnetic anisotropy but increases maximum permeability, thereby demonstrating excellent magnetic properties. However, since the elongation that is a kind of mechanical properties abruptly decreases depending on an increase in silicon content, it is known that up to 3.3% Si is contained in a starting material to which the cold rolling enabling the mass production of electrical steel is applicable.

Accordingly, the inventor has researched processes for manufacturing high silicon electrical steel sheets by using a conventional electrical steel sheet manufacturing process employing the cold rolling, which enables mass production. As a result, the inventor has found that a grain-oriented electrical steel sheet with very excellent magnetic

properties can be manufactured by a process comprising the steps of: preparing slurry formed by dispersing a powder coating agent in water or the like, the powder coating agent being made by mixing an sintered powder of Fe-Si group having a predetermined grain size and Si content with MgO powder as the annealing separator; coating the prepared slurry on a surface of a decarburized and nitrogen-annealed electrical steel sheet; diffusion annealing the resultant steel sheet during the high temperature annealing process to complete a high silicon content and magnetic properties by a second recrystallization, and suggests the present invention.

That is, in the present invention, in order to prevent sticking between materials while a high temperature annealing for secondary recrystallization is performed to manufacture a conventional grain-oriented electrical steel sheet, annealing separator is inevitably coated on a surface of a steel sheet. At this time, the annealing separator is coated in a state that an Fe-Si-based sintered powder group having a predetermined grain size and Si content is added to MgO powder as main component of the annealing separator, so that a high silicon grain-oriented electrical steel sheet can be manufactured through a subsequent high temperature annealing process. In other words, the present invention can produce a high silicon

grain-oriented electrical steel sheet with very excellent magnetic properties while employing the conventional process for manufacturing grain-oriented electrical steel sheet using the cold rolling.

5 First, the inventive siliconizing powder coating agent will be described in concrete.

When contacting silicon (Si) with Fe metal under high temperature hydrogen or nitrogen atmosphere more than 950 °C, there occurs an interdiffusion reaction where Si atoms
10 diffuse into Fe metal and Fe atoms diffuse into Si containing metal to make the concentration of Fe and Si in both sides to be identical. Accordingly, when contacting Si metal powder on a matrix portion of the electrical steel sheet and then annealing the electrical steel sheet at a
15 high temperature, an interdiffusion reaction may be progressed by an intermovement of metal Si and matrix Fe because the concentration of the Si powder is considerably higher than the Si concentration of 3% level in the surface of the grain-oriented electrical steel sheet.

20 When comparing the interdiffusion reaction of Fe atoms and Si atoms, since the diffusion rate of Si atoms is faster approximately two times than that of Fe atoms in a temperature range of 1000 - 1200 °C, there occurs a phenomenon called Kirkendall effect corresponding to a non-
25 homogeneous diffusion state. This non-homogeneous diffusion

state causes non-homogeneous state defects at a reaction interface or creates various compounds such as FeSi_2 , FeSi , Fe_5Si_3 and Fe_3Si , which act as a factor deteriorating magnetic properties. Accordingly, in case where only the metal Si powder is used as the siliconizing agent, it is in fact impossible to produce high silicon grain-oriented electrical steel sheets having homogeneous composition without surface defects through a high temperature diffusion annealing.

To solve the above problem, the inventor repeated researches on diffusion principle and so forth using Si powder and Fe powder, and finally found that the defects in the diffusion reaction portion are based on faster diffusion rate of Si than Fe. Accordingly, the inventor suggests the present invention.

That is, the present invention is characterized by controlling grain size and composition of Si-containing powder agent used as the siliconizing agent so as to suppress the Si diffusion relative to the Fe diffusion. In other words, the present invention is characterized by providing an Fe-Si-based sintered powder controlled to have a predetermined grain size and composition to enable diffusion where Si atoms and Fe atoms are substituted with each other by an identical amount nearly without forming a composite compound where Fe and Si are bonded to each other

at a diffusion reaction portion of the steel sheet surface, mixing the provided powder with annealing separator of MgO powder to form a mixture, and utilizing the mixture as the siliconizing coating agent.

5 Hereinafter, the above characteristics will be described in more concrete.

First, to further slack the diffusion rate of Si component, powder containing only Si metal is not used but Fe-Si-based compound such as FeSi_2 , FeSi , Fe_5Si_3 , and Fe_3Si
10 that Si metal is bonded to Fe metal is used as the main composition of the siliconizing coating agent.

Fe-Si-based powder used in the present invention can be manufactured by mixing Fe powder and Si powder with each other, and sintering the mixed powder at a temperature
15 range of 1000 - 1200°C in a mixture gas atmosphere of hydrogen and nitrogen for 5 - 10 hours, but is not necessarily restricted thereto and can be manufactured by various methods. At this time, the component ratio of the sintered powder compound is changed depending on the mixed
20 amount of Fe powder and Si powder. Theoretically, when the mixed amount is 50%Si+50%Fe, compound of FeSi_2 is created, when the mixed amount is 34%Si+66%Fe, compound of FeSi is created, when the mixed amount is 25%Si+75%Fe, compound of Fe_5Si_3 is created, and when the mixed amount is 14%Si+86%Fe,
25 compound of Fe_3Si is created. However, in actual annealing,

small amounts of several compounds may exist according to an initial mixing state. In particular, when an annealing reaction is generated by a mixing of Fe powder and Si powder, reaction is progressed in such a manner that Si atoms and Fe atoms are interdiffused to invade. Hence, although the amount of Si is somewhat large, the annealed powder becomes a state in which surfaces of the sintered powder contain most of FeSi_2 compound or FeSi compound corresponding to a state that Fe atoms have been diffused exist but pure Si atoms exist at inside of the sintered powder. Accordingly, most of Fe-Si-based compound exist in the surface of the sintered powder.

In the present invention, Si content in the Fe-Si-based sintered powder obtained as above is restricted to 25 - 70 wt%. If the Si content is less than 25wt%, it is so small and thus diffusion rate may be very slow. Also, the high density of the annealed powder may cause the drop of the dispersion when the coating process is performed in practice. Since the content of Si exceeding 70wt% allows main component to exist as FeSi_2 and a mixture of extra metal Si phase, metal Si component contacts with the surface of material to increase the creation possibility of defects on surface during the siliconizing process so that the control of the silicon content as siliconized may be difficult. In other words, by restricting the Si content

contained in Fe-Si-based sintered powder to a range of 25 - 70 wt%, it is possible to manufacture Fe-Si-based composite compound sintered powder having FeSi_2 , FeSi , Fe_5Si_3 or Fe_3Si as a main component. It is more preferable that the content of $\text{FeSi}_2+\text{FeSi}$ among the Fe-Si-based composite compounds should be restricted to 90wt% or more with respect to the total weight of the sintered powder.

When Fe-Si-based sintered powder manufactured as above is mixed with MgO powder and is used as coating agent of electrical steel sheet, this mixed powder is made in a slurry state and coated on the surface of the steel sheet by using a roll coater, which is most economical in production stage. The Fe-Si-based sintered powder as siliconizing agent should be made as fine as possible, which enhances the coating workability in a production stage and is advantageous in terms of management of surface shape on diffusion reaction. However, since the Fe-Si-based sintered powder where annealing reaction is completed is in a state of fused lump by a high temperature and long term reaction, it is necessary to control the grain size of the powder as fine as possible.

Accordingly, the present invention makes the grain size of Fe-Si-based sintered powder finely considering such a circumstance. Finer grain enhances the dispersity toward slurry state and improves the coatability. Also, by coating

fine Fe-Si-based sintered powder on surface of steel sheet, surface contact area between the matrix material and the metal powder, i.e., interreaction area can be reduced to 30% or less compared with a single sheet contact. It is
5 desirable that the grain size should be restricted to -325 mesh upon considering the productivity and costs for formation of fine powder.

Also, the inventive powder coating agent is prepared by mixing Fe-Si-based sintered powder obtained as above
10 with MgO powder of annealing separator. Specifically, the inventive powder coating agent is prepared by mixing 100 part by weight of MgO, which is main component of the annealing separator, with 0.5 - 120 part by weight of the Fe-Si-based sintered powder. At this time, if the added
15 amount of the sintered powder is less than 0.5 parts, the silicon content as siliconized is few or too small. If the added amount exceeds 120 parts, the dispersity of the sintered powder with MgO is poor, so that it is difficult to control the dispersity with MgO powder and to control
20 the silicon content as siliconized according to the region of the matrix material, which is undesirable.

Next, a manufacturing process of a high silicon grain-oriented electrical steel sheet using the powder coating agent will be described.

25 As aforementioned, the invention utilizes the

conventional manufacturing process of a grain-oriented electrical steel sheet including the steps of: producing a steel slab; reheating the steel slab; hot rolling the reheated steel slab; annealing the hot-rolled sheet and
5 cold rolling the annealed steel sheet to adjust the thickness of the steel sheet; decarburization annealing the cold-rolled steel sheet; performing a high temperature annealing of the steel sheet for a secondary recrystallization; and finish coating an insulating film.
10 However, the invention is not limited to the above concrete manufacturing process. For instance, the inventive process may omit the hot rolled sheet annealing step, or can be applied to a manufacturing process of an electrical steel sheet including the nitrizing step together with the
15 decarburization annealing.

The invention does not limit the initial composition of the steel slab, but it is desirable that the steel sheet to be coated with the siliconizing powder coating agent in the form of slurry contains 2.9 - 3.3 wt% Si. If the Si
20 content is less than 2.9 wt%, core loss becomes severe, and if the Si content exceeds 3.3 wt%, the steel sheet is brittle so that cold rolling characteristic is very poor. More preferably, the steel sheet contains C: 0.045 - 0.062 wt%, Si: 2.9 - 3.3 wt%, Mn: 0.08 - 0.16 wt%, Al: 0.022 -
25 0.032 wt%, N: 0.006 - 0.008 wt%, remnant iron and

inevitable impurity.

Considering securing the hot rolling property and the magnetic properties, the steel slab is reheated at a temperature range of 1150 - 1340 °C, and is then hot rolled so that a hot rolled steel sheet with a thickness of 2.0 - 2.3 mm is made. Afterwards, hot rolled annealing is performed at a temperature below 1100 °C, and picking and cold rolling are performed to control the thickness of the steel sheet to a range of 0.20 - 0.30 mm that corresponds to a final thickness. In case of 0.2 mm products, twice hot rolled annealing and cold rolling are performed to control the thickness of the steel sheet to the final thickness. After that, under a moisture atmosphere containing hydrogen and nitrogen, decarburizing treatment is performed at an approximate temperature range of 840 - 890 °C to obtain a decarburization annealed steel sheet. The aforementioned steps are well known in conventional arts, and the invention is not limited only to these concrete process conditions.

The invention utilizes the decarburized steel sheet as the matrix steel sheet, which has a thin oxide layer formed on a surface thereof. Then, the thin oxide layer acts as a hindrance layer of interdiffusion reaction during the siliconizing annealing process and functions to decrease the amount of Si atoms diffused toward the inside of the

matrix steel sheet. Accordingly, this thin oxide layer may be more advantageous in manufacturing an electrical steel sheet with superior core loss characteristics.

Specifically, Fe-Si-based composite compound sintered powder is mixed with MgO powder to prepare powder coating agent. The powder coating agent is dispersed in water and is made in a slurry state. After that, the slurry coating agent is coated on the surface of the decarburized and nitridation annealed steel sheet by using a roll coater. At this time, the coating amount of the slurry coating agent is determined by the following formulas 1 and 2:

$$Y - 0.25 \leq \text{coating amount} \leq Y + 0.25 \text{ -----formula 1,}$$

and

$$Y(\text{g/m}^2) = 28(x_1 - x_2)/(A - 14.4)B + 0.8 \text{ ---formula 2.}$$

where A is a Si content (%) in the Fe-Si-based sintered powder, B is a mixture ratio of Fe-Si-based powder contained in annealing separator composition, x_1 is a target Si content (%) of matrix material, and x_2 is an initial Si content of matrix material.

Thus, the steel sheet coated with the coating agent is dried and coiled in a large-sized hot rolled coil. It is desirable that the drying temperature is restricted to a temperature range of 200 - 700 °C. If the drying temperature is less than 200 °C, the drying time is too long so that productivity is lowered. If the drying temperature exceeds

700 °C, oxide may be created on a surface of the steel sheet.

After that, the dried steel sheet is finish-annealed at a high temperature under a general annealing condition. In other words, the invention can use a general high
5 temperature annealing process of a grain-oriented electrical steel sheet in which the annealing temperature is elevated up to 1200 °C under a mixture gas atmosphere of nitrogen and hydrogen, and the steel sheet is uniformly heated at 1200 °C for 20 hours or more, and then cooled.

10 Only to secure more superior magnetic properties by siliconizing the steel sheet coated with the powder coating agent during the finish-annealing process, it is more desirable to consider the following conditions:

First, in this general high temperature annealing
15 process, secondary recrystallization is completed at a temperature range up to about 1100 °C. Accordingly, it is more preferable to induce the Si diffusion reaction by the Fe-Si-based composite compound coating agent since 1100 °C when the magnetic properties are completed. Accordingly, it
20 is preferable that the steel sheet is heated in an atmosphere of 100% nitrogen gas in a temperature range of from the temperature elevation start to 1100 °C to minimize the silicon content as siliconized below 0.25% if possible. In the temperature elevation process of this high
25 temperature annealing, the content ratio of nitrogen gas

among the atmosphere gases is increased to form a thin oxide on a surface of the matrix material, thereby effectively suppressing inner diffusion of Si.

Second, after 1100 °C where the secondary
5 recrystallization is completed, it is preferable to anneal the steel sheet at a hydrogen containing atmosphere containing less than 10% nitrogen in an aspect of the control of Si content targeted to maximize the siliconizing.

By doing so, glass film starts to be formed and at the
10 same time that secondary recrystallization is completed in a temperature elevating range up to 1100 °C of the high temperature annealing process. After that, siliconizing reaction is completed in a temperature elevating period of 1100 - 1200 °C and in a long term uniform heating period of
15 1200 °C to thereby form glass film.

Non-reacted composition remaining on the surface of the high temperature annealed steel sheet is removed by an acid solution, and then an insulation coating agent where a small amount of chroic acid is added to mixture phosphate
20 of magnesium (Mg), aluminum (Al) and Calcium (Ca) and colloidal silica component, is coated on the steel sheet to thereby obtain high silicon grain-oriented electrical steel sheet products with maximum magnetic properties.

25 Hereinafter, the present invention will be described

in more detail with embodiments.

Embodiment 1

Steel slabs each containing Si: 3.05% by weight, C:
5 0.046% by weight, P: 0.015% by weight, dissolved Al: 0.026%
by weight, N: 0.0073% by weight, S: 0.005% by weight, Mn:
0.11% by weight, Cu: 0.12% by weight, remnant Fe and
inevitably contained impurity were reheated at a
temperature of 1190 °C, then hot-rolled annealed and pickled
10 at a temperature below 1100 °C. After that, the hot rolled
steel sheets were cold rolled so as to have a thickness of
0.20 - 0.30 mm. The steel sheet having the thickness of
0.20 mm was additively hot rolled annealed in the course of
rolling so as to secure a final cold rolled rate. The cold
15 rolled steel sheets were decarburized at an annealing
temperature of 880 °C under a moisture atmosphere containing
mixture gases of hydrogen and nitrogen to control the
remnant carbon content and at the same time obtain
decarburized annealed steel sheets each containing a total
20 oxygen content of 610ppm in the surface thereof.

Next, one of the obtained cold rolled steel sheets was
coated with annealing separator formed by adding 3% TiO₂
powder to 100 part by weight of MgO corresponding to the
manufacturing condition of the conventional normal product,
25 to manufacture a grain-oriented electrical steel sheet. The

remaining cold rolled steel sheets were coated with powder coating agents, which were dispersed in water and made in a slurry state and have different compositions and different grain sizes as shown in table 1, by using a roller coater.

5 After that, these steel sheets were dried at a temperature below 700 °C and coiled to obtain large-sized coils.

The coiled grain-oriented electrical steel sheets were annealed elevating the temperature of an annealing furnace containing atmosphere gas of 40% nitrogen + 60% hydrogen up
10 to 1200 °C, were uniformly heated at a temperature of 1200 °C in an atmosphere of 100% hydrogen for 25 hours and cooled. Non-reacted substances on the surface of the steel sheets are removed by hydrochloric acid, and then an insulation coating agent where a small amount of chroic acid was added
15 to mixture phosphosphate of magnesium (Mg), aluminum (Al) and Calcium (Ca), and colloidal silica component, was coated on the steel sheet to form an insulation coating film, thereby manufacturing final grain-oriented electrical steel sheet products.

20 In the products manufactured as above, Si content and magnetic properties were examined. The magnetic properties, i.e., core loss and magnetic flux density (B8) are examined by a single sheet measuring device, and are shown in the below table 1. The coating state of annealing separator
25 coating composition corresponds to results observed in

visual inspections of appearance of coating agent. Product core loss $W_{17/50}$ represents the core loss at a frequency of 50 Hz and magnetic induction of 1.7 Tesla, $W_{10/400}$ represents the core loss at a frequency of 400 Hz, 1.0 Tesla, and $W_{5/1000}$ represents the core loss at a frequency of 1000 Hz, 0.5 Tesla, respectively. The magnetic flux density B_8 represents magnetic flux per unit area, which is generated when being subject to a magnetizing force of 800A-turn/m, and matrix Si content is a wet analysis result value.

10

Table 1

No.	Fe-Si powder (as referenced by 100 part by weight of MgO)			Coating state	Magnetic properties				Si conte nt (%)
	Si conte nt (%)	Grain size (mesh)	Added amount		B_8 (Tesla)	$W_{17/50}$ (W/Kg)	$W_{10/400}$ (W/Kg)	$W_{5/1000}$ (W/Kg)	
1	-	-	3	Good	1.92	0.90	7.9	9.3	3.0
2	15	-325	40	Thin	1.87	0.86	7.0	8.5	3.4
3	35	-325	40	Good	1.85	0.83	6.8	7.2	3.9
4	50	-325	40	Good	1.85	0.81	6.6	7.0	4.2
5	65	-325	40	Good	1.83	0.79	6.3	6.6	4.5
6	80	-325	40	Good	1.75	1.56	12.21	15.34	5.4
7	100	-325	40	Thick	1.69	1.98	17.01	21.17	5.7
8	60	-150~ +250	40	Thin, non- uniform	1.84	0.81	6.8	7.1	4.2
9	60	-250~ +325	40	Thin	1.84	0.80	6.6	7.0	4.4
10	60	-450	40	Good	1.82	0.79	6.5	6.8	4.6
11	60	-325	0.2	Good	1.91	0.90	7.8	9.2	3.0

12	60	-325	70	Good	1.79	0.75	5.9	5.7	5.2
13	50	-325	115	Good	1.83	0.76	5.9	6.1	4.8
14	50	-325	130	Non-uniform	1.77	0.87	7.3	8.4	5.8

As seen from table 1, the inventive electrical steel sheets 3 to 5, 10, 12 and 13 manufactured using coating agent, which is prepared by mixing Fe-Si-based sintered powder configured having a predetermined grain size and composition with MgO powder were increased in Si content from 3% at an initial stage to 3.9 - 4.5 %. In core loss $W_{10/400}$ and $W_{5/1000}$ in high frequency band as well as core loss $W_{17/50}$ in commercial frequency band, the inventive samples show superior magnetic properties having much less core loss compared with those of the conventional sample 1.

In case of the electrical steel sheet 2 containing approximately 15% Si, small coating amount and small silicon content as siliconized made the improvement in core loss small. In case of the electrical steel sheets 6 and 7 containing 85% Si and 100% Si, although coated film became thick and Si content was made high, a large amount of defects were created at the surface of the samples, so that core loss was increased. Accordingly, these samples 6 and 7 were excluded from the range of the present invention.

Also, in case of the electrical steel sheets 8 and 9 having grain sizes, which are outside the grain size range of the invention, dispersity of slurry solution is poor so

that coating agent is coated thin and non-uniform. The magnetic properties after the siliconizing were comparatively good but feature values depending on regions of the material existed. Accordingly, these samples 8 and 9 were excluded from the range of the present invention.

In the meanwhile, in case of the electrical steel sheet 11 where the content of Fe-Si-based powder is small compared with that of MgO powder, siliconizing was almost not generated so that improvement in the magnetic properties was impossible. In case of the electrical steel sheet 14, slurry dispersed state was poor and coated state was non-uniform, so that magnetic properties were poor and deviation according to regions existed. So, these samples 11 and 14 were excluded from the range of the present invention.

Embodiment 2

Steel slabs each containing Si: 3.20% by weight, C: 0.045% by weight, P: 0.014% by weight, dissolved Al: 0.027% by weight, N: 0.0075% by weight, S: 0.005% by weight, Mn: 0.10% by weight, Cu: 0.12% by weight, remnant Fe and inevitably contained impurity were reheated at a temperature of 1150 °C, then hot-rolled annealed and pickled at a temperature below 1100 °C. After that, the hot rolled steel sheets were cold rolled so as to have a final

thickness of 0.23 mm. Thereafter, the cold rolled steel sheets were decarburized at the same time at an annealing temperature of 880 °C under a moisture atmosphere containing mixture gases of hydrogen and nitrogen to obtain
5 decarburized annealed steel sheets.

Next, siliconizing composition was formed in slurry state by mixing 25 part by weight of Fe-Si-based sintered powder having a grain size of -325mesh and containing 50% Si with 100 part by weight of MgO and then dispersing the
10 mixture in water. The siliconizing composition was coated on the surfaces of the obtained decarburized annealed steel sheets by a roll coater. After that, the steel sheets were dried and coiled to obtain large-sized coils.

The coiled grain-oriented electrical steel sheets were
15 finish-annealed so as to secure magnetic properties and siliconization due to secondary recrystallization as shown in the below table 2. Specifically, the steel sheets were subject to a heating cycle in which the temperature of an annealing furnace was elevated starting from a low
20 temperature soaking in a temperature below 600 °C for a predetermined time period to 1200 °C in a temperature rise rate of 15 °C per hour. During the heating cycle, high temperature annealing conditions were varied as shown in table 2. In the meanwhile, in the course of the annealing,
25 some samples at 1100 °C were extracted and an increase in Si

content in the extracted samples was examined. The results are shown in the below table 2.

Non-reacted substances on the surface of the steel sheets were removed by hydrochloric acid, and then an insulation coating agent where a small amount of chroic acid was added to mixture phosphate of magnesium (Mg), aluminum (Al) and Calcium (Ca), and colloidal silica component was coated on the steel sheets to form an insulation coating film, thereby manufacturing final grain-oriented electrical steel sheet products.

In the products manufactured as above, Si content and magnetic properties were examined. The appearance state of the coating film and the standard for determining magnetic properties were evaluated under the same standard as that of embodiment 1.

Table 2

No.	High temp annealing condition					Magnetic properties			Product Si (%)
	Soaking temp. (°C)	Soaking time (Hr)	Gas 1	Gas 2	Si, 1100°C (%)	B ₈ (Tesi a)	W _{17/50} (W/Kg)	W _{5/1000} (W/Kg)	
1	400	20	100	0	0.18	1.77	0.72	6.4	4.5
2	500	15	100	0	0.12	1.78	0.71	6.5	4.2
3	450	12	100	0	0.22	1.77	0.73	6.4	4.3
4	450	12	100	10	0.18	1.76	0.72	6.3	4.5

* Gas 1 : Annealed gas atmosphere up to 1100°C is expressed by a ratio (%) of $N_2/(N_2+H_2)$.

Gas 2 : Annealed gas atmosphere of from 1100°C to end is expressed by a ratio (%) of $N_2/(N_2+H_2)$.

5. As shown in the above table 2, it is known that by more optimally controlling the high temperature annealing condition, Si content in matrix after completion of the annealing is changed to 4.2 - 4.5% so that the inventive steel sheets are siliconized, and superior core loss
10 characteristics of W17/50: 0.71 - 0.72 and W5/1000: 6.4 - 6.5 can be obtained.

Although the present invention has been shown and described with reference to the above preferred embodiment, it is not to be understood that the invention is limited
15 thereto. Rather, it will be apparent to those skilled in the art that various modifications and changes may be made therein without departing from the spirit and scope of the invention as defined by the appended claims.

20 INDUSTRIAL APPLICABILITY

As described above, although utilizing the conventional general manufacturing process, the present invention can coat siliconizing coating composition on steel sheet instead of MgO composition as annealing
25 separator prior to the finish high temperature annealing

and siliconize the coated siliconizing coating composition to manufacture a grain-oriented electrical steel sheet having superior magnetic properties and a thickness of 0.2 - 0.30 mm at a low production cost.